

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72356

Friday, July 22, 2011 2:51:26 PM

Page 2

Item ID: D2432

Accept

Setup Start

Revision ID:

Stop

Item Name: 206 (24") Bearpaw

Start Date: 7/22/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/09/13

8

0

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP 68671 8P 11-09-14.

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

11/09/14 (4)

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Picklist Print

Friday, July 22, 2011 2:51:34 PM

Page 1

Work Order ID: 72356

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

501.2200

3.7

29.6



UHMW 1" Black



181-8-16

Location

Loc Qty

Loc Code

MAT018

501.22

117321

76.6

117738

166.3

117819

129.9

118257

128.42

117738

8

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DART AEROSPACE LTD		Work Order: 72354
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.0063	/		
B	5.500	+/-0.030	5.503	/		
C	0.200	+/-0.030	.193	/		
D	0.25 x 45°	+/-0.030	.257	/		
E	R0.250	+/-0.030	.250	/		
F	0.250	+/-0.010	.242	/		
G	0.625	+/-0.030	.618	/		
H	0.375	+/-0.010	.376	/		
I	0.950	+0.030/0.010	.940	/		
J	19.000	+/-0.030	19.000	/		
K	3.14	+/-0.030	3.14	/		
L	3.28	+/-0.030	3.275	/		
M	Ø0.260	+0.005/-0.000	.260	/		
N	Ø0.93	+/-0.030	.925	/		
O	0.30	+0.030/-0.000	.308	/		
P	23.750	+/-0.030	23.750	/		
Q	7.375	+/-0.030	7.375	/		
R	4.250	+/-0.010	4.250	/		
S	2.000	+/-0.030	2.014	/		
T	9.000	+/-0.010	9.000	/		
U	9.000	+/-0.010	9.000	/		
V	0.375	+/-0.010	.380	/		

Measured by: FK/RP	Audited by: B.A	Prototype Approval:	N/A
Date: 11/09/13	Date: 11/09/13	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

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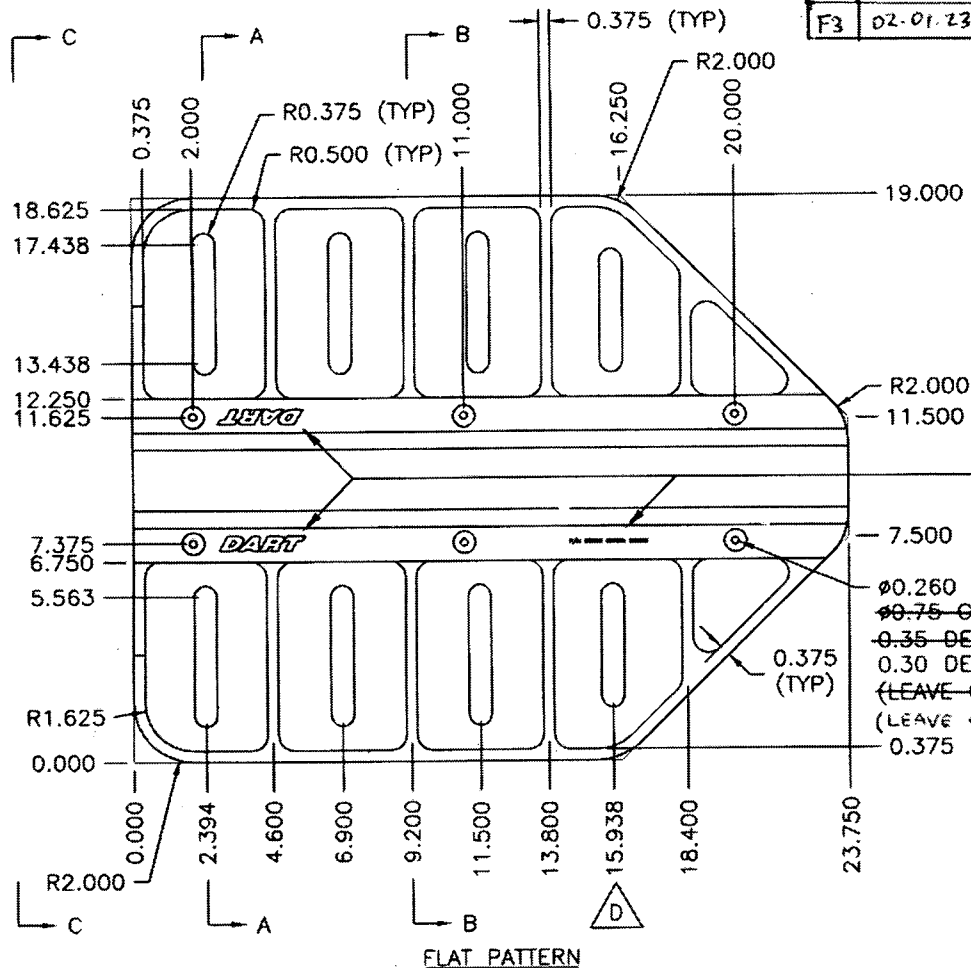
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F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.)
 (LEAVE 0.650 MIN.)

EFFECTIVE	DEOS
9143	

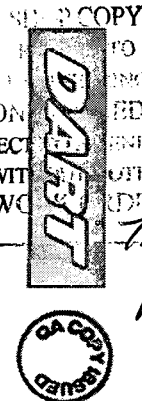
D2432F: FLAT BEARPAW
 D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
 1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	MM	D2432
DATE	TITLE	SHEET 1 OF 2
98.05.12	BEARPAW	SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

RELEASED
 98.06.12 KE

UNCON
 SUBJECT
 WIT
 WO
 NO.



72354
 11/07-22

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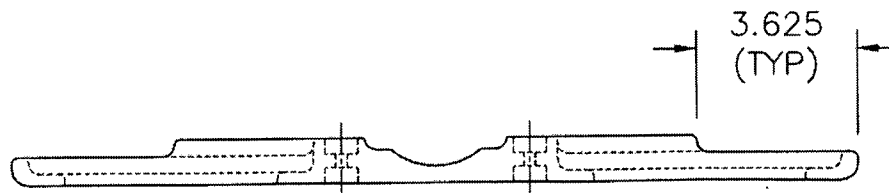
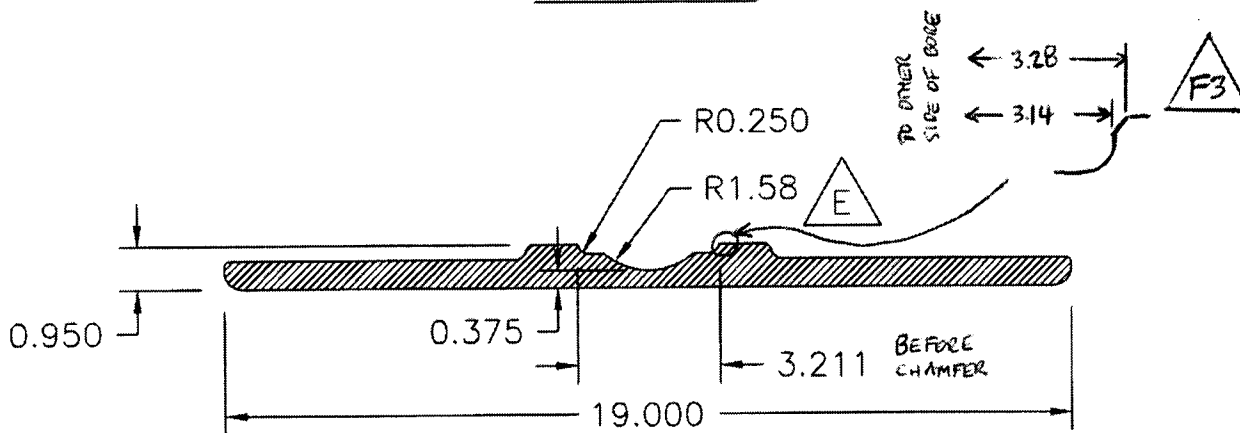
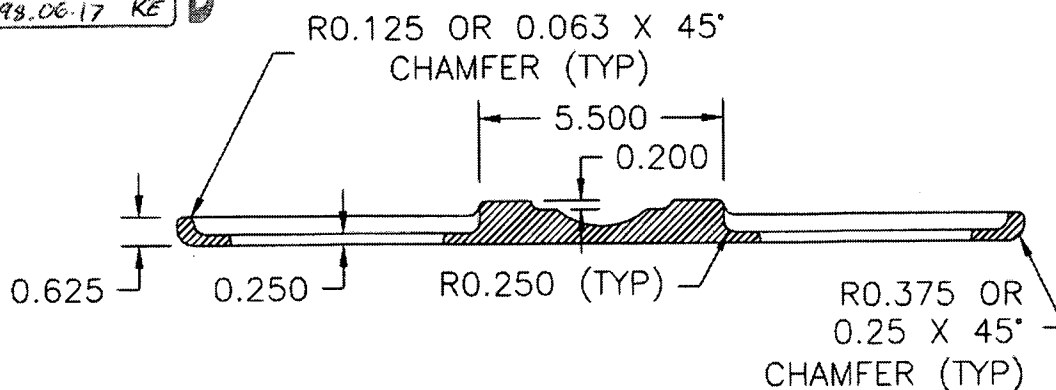
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

72356



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